

FOR INFORMATION ON SPARE BALANCE
WEIGHTS SEE R201/A3/3255

FOR ASSEMBLY AND PEENING OF BALANCE
WEIGHTS SEE R201(A2)2760

CARE TO BE TAKEN TO ENSURE THAT ONLY
IMPERIAL THREAD BALANCE WEIGHTS BE
USED IN ROTOR BALANCING - SEE PARTS LIST.

*BALANCE AND OVERSPEED OF ROTOR TO BE
IN ACCORDANCE WITH GEC PROCESS SPEC 601/0020

NOTE
BEFORE ASSEMBLY ALL STUDS, BOLTS, NUTS, ETC
ARE TO HAVE THREADS AND MATING SURFACES
COATED WITH GREASE IN ACCORDANCE WITH
CONTRACT REQUIREMENTS.
IN ADDITION ALL FASTENERS 3,7 & 11
TO BE CONTROL TIGHTENED TO THE TORQUE
LOADINGS GIVEN BELOW.

STEAM FLOW

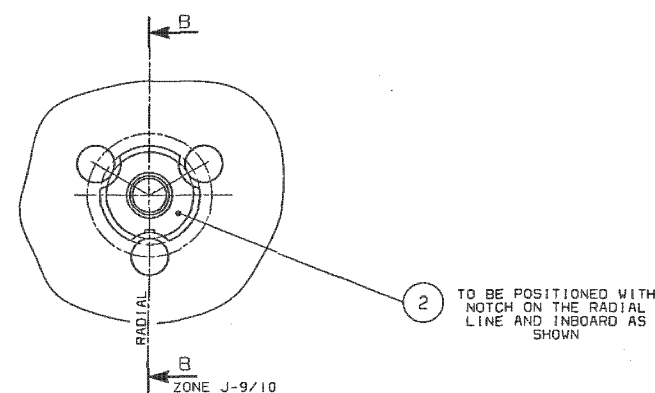
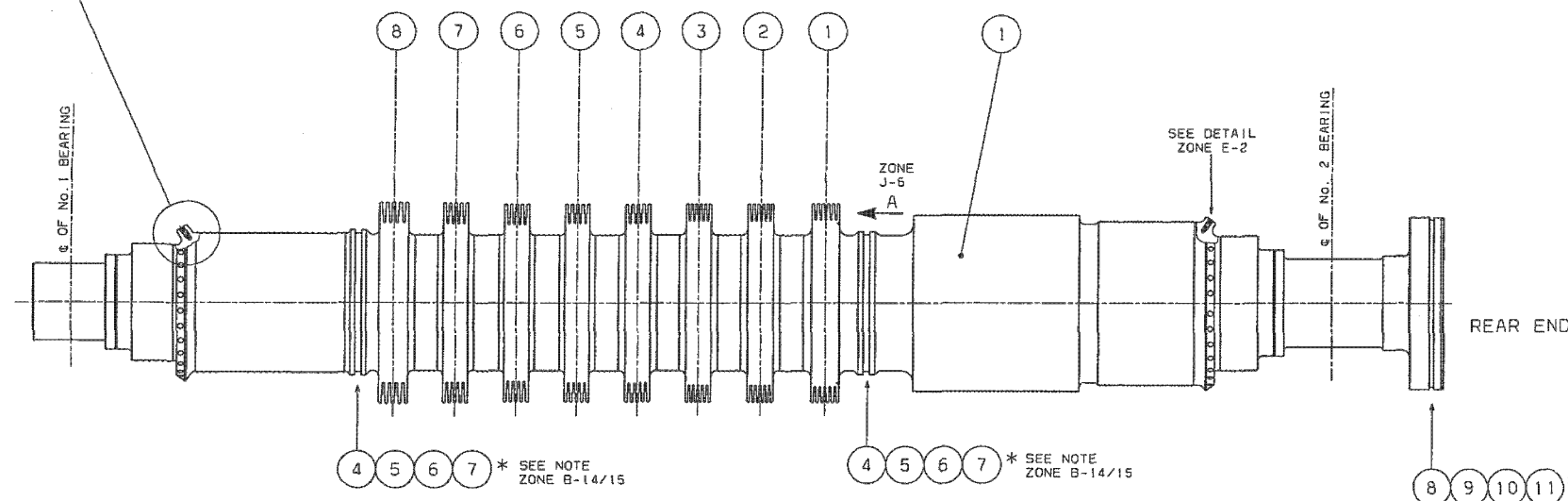
ANTI-CLOCKWISE ROTATION

R. H. BLADES

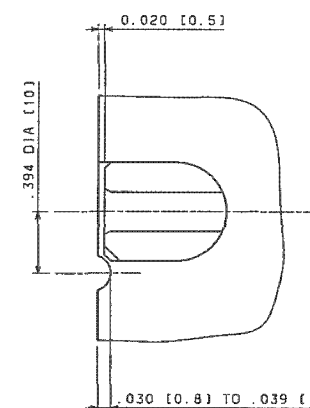
FRONT END

REAR END

BLADE DISPOSITION DIAGRAM



TYPICAL VIEW ON ARROW A
ZONE D-9
SCALE 5:1



SECTION 8-E
ZONE J-6

PLUG TO BE SECURED INTO THE DISC
BY THREE EQUIDISTANT INDENTS PRODUCED
BY 120 (031) SPHERICAL ENDED TOOL
ONE OF THE INDENTS TO BE ON THE DISC
RADIAL LINE WHICH PASSES THROUGH THE
CENTRE OF THE PLUG AND IS TO COINCIDE WITH
THE ANTI-ROTATION NOTCH. THIS INDENT IS TO
BE ON THE INBOARD SIDE OF THE PLUG.
AFTER FORMING THE INDENTS, THE ASSEMBLY
IS TO BE INSPECTED FOR CRACKS BY VISUAL
EXAMINATION. NO CRACKS TO BE ACCEPTED.